

Date: Tuesday, 4/24/2007 3:14:56 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: STEP SPACER		
Job Number	: 32032D		Part Number	: D30657		
Estimate Number	: 10380		Drawing Number	: D3065 REV. B		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 4/24/2007	S.O. No. : N/A	Drawing Revision	: B		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 5/20/2007		
Previous Run	: 31794D		Qty:	60	Um:	Each
Written By	:					
Checked & Approved By	:					
Comment	: Est:C 02/11/01 Incorporated D3066-1 IPP KJ/RF Est Rev:D Now on Water Jet 06-04-11 JLM					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S040	2024-T3 .040 sheet 
Comment: Qty.: 0.1653 sf(s)/Unit Total : 9.9162 sf(s) Material: 2024-T3 (QQ-A-250/4) 0.040" thick (M2024T3S.040) Batch: <u>M104025</u> <span style="float: right;">SAD 07/05/26</span>		
2.0	WATER JET	FLOW WATER JET 
Comment: FLOW WATER JET 1-Cut as per Dwg D3065 Dwg Rev: <u>B</u> Prog Rev: <u>B</u> <span style="float: right;">SAD 07/05/26 60 </span>		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE 
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <span style="float: right;">SAD 07/05/26 60</span>		
4.0	QC8	SECOND CHECK 
Comment: SECOND CHECK <span style="float: right;">SAD 07/05/26 60</span>		
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1 
Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr if necessary. <span style="float: right;">SAD 07/06/03 60</span>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3065-7 PAR #: N/A Fault Category: Prop - Sm Ld Wt. NCR  Yes No DQA: AA Date: 07/07/20  
 QA: N/C Closed: AA Date: 07/07/23

NCR: <u>32032D</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>07/05/20</u>	<u>2.0</u>	<u>Scrap one part because of Machine offset holes were to big</u>	<u>2</u> <u>QSI042</u>	<u>Scrap destroy and replace same B/N</u>	<u>SA</u> <u>07/05/20</u>	<u>SP</u> <u>07/07/20</u>	<u>2</u> <u>QSI042</u>	<u>SP</u> <u>07/07/20</u>

NOTE: Date & initial all entries

Date: Tuesday, 4/24/2007 3:14:56 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP SPACER

Job Number: 32032D

Part Number: D30657

Job Number:



Seq. #: Machine Or Operation:

Description:

6.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Bend as per Dwg D3065

SB 07/07/17 (60)

7.0 QC5 INSPECT WORK TO CURRENT STEP



counter

Comment: INSPECT WORK TO CURRENT STEP

SB 07/07/18 (60)

8.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

07-07-18 (60)

9.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

SB 07/07/19 (60)

10.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

SB 07/07/19 (60)

11.0 QC21 FINAL INSPECTION/W/O RELEASE



07.07.19 (60)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 07/07/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	37032-D
Description: Step Spacer	Part Number:	D3065-7
Inspection Dwg: D3065	Rev: B	Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

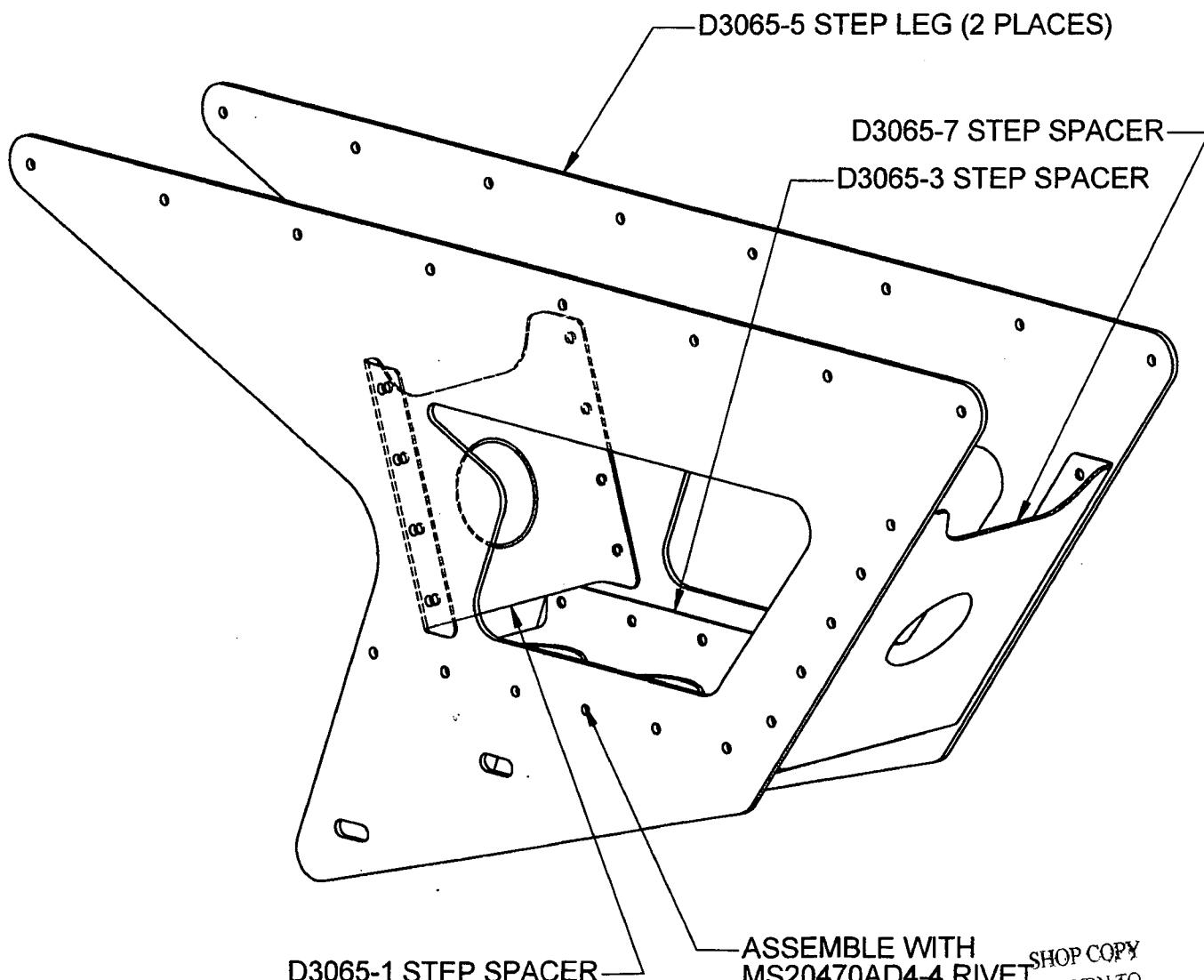
## X First Article | Prototype

Measured by:	SAD	Audited by:	SC	Prototype Approval:	N/A
Date:	07/05/26	Date:	07.05.26	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D3065-041	KJ/RF	
B	04.05.15	Removed 0.531, 3.686, 0.580; Added 3.936 dimensions	KJ/JLM	
C	06.06.23	Dwg Rev. changed	KJ/JLM	

**DART**

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA				
CHECKED	APPROVED	DRAWING NO.	REV. B SHEET 1 OF 5			
PH	<del>PH</del>	D3065				
DATE	06.05.23	TITLE	SCALE 1:2			
A	02.09.11	STEP LEG ASSEMBLY				
B	06.05.23	ADD 6061-T6 MATERIAL, ADD SLOTS TO D3065-5				

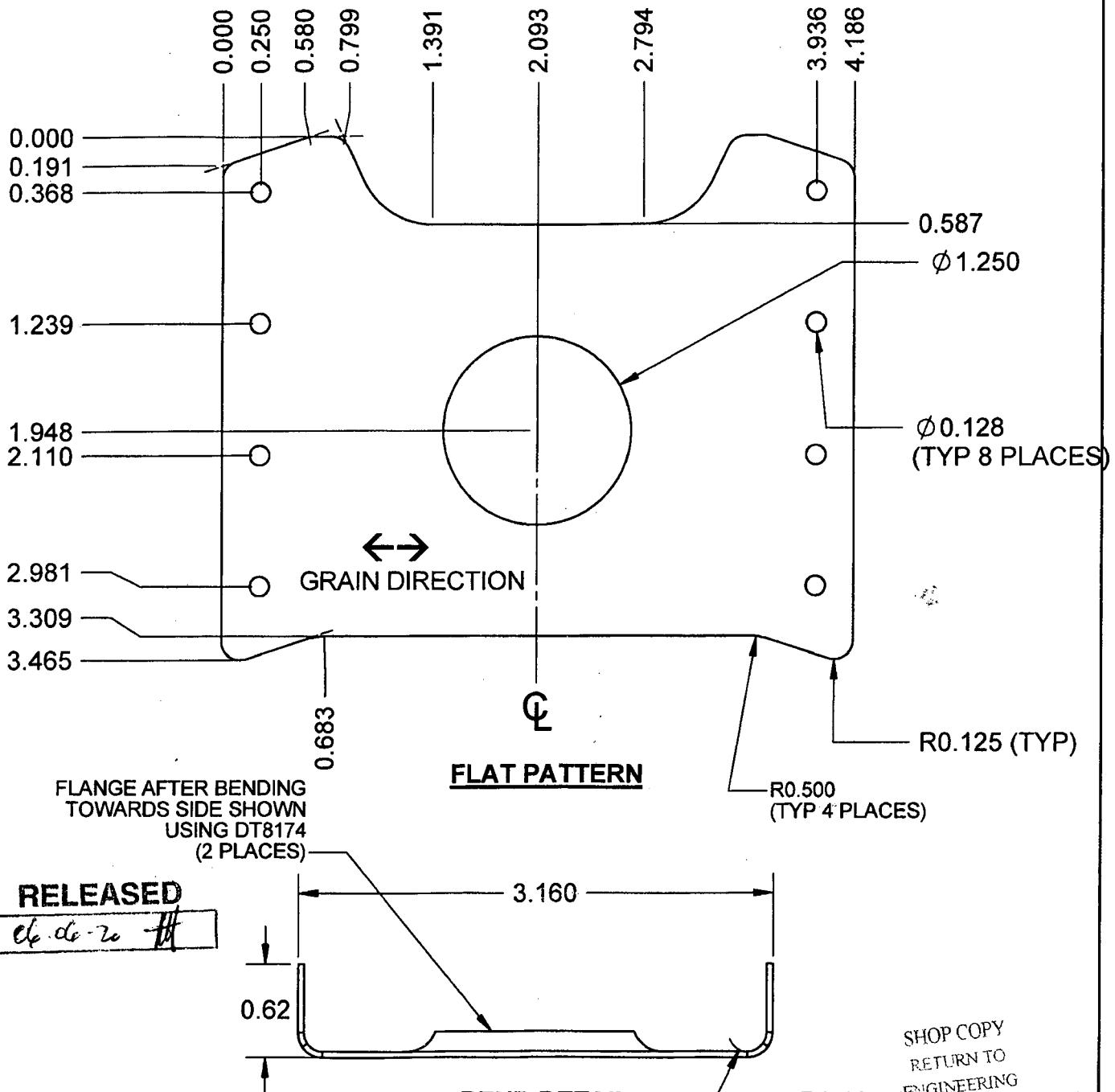
**RELEASED**06.06.20 ~~PH~~**D3065-041 STEP LEG ASSEMBLY**

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CHECKED <i>PH</i>	APPROVED <i>AA</i>	DRAWING NO. D3065	REV. B	SHEET 2 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1	

**D3065-1 STEP SPACER**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S-040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

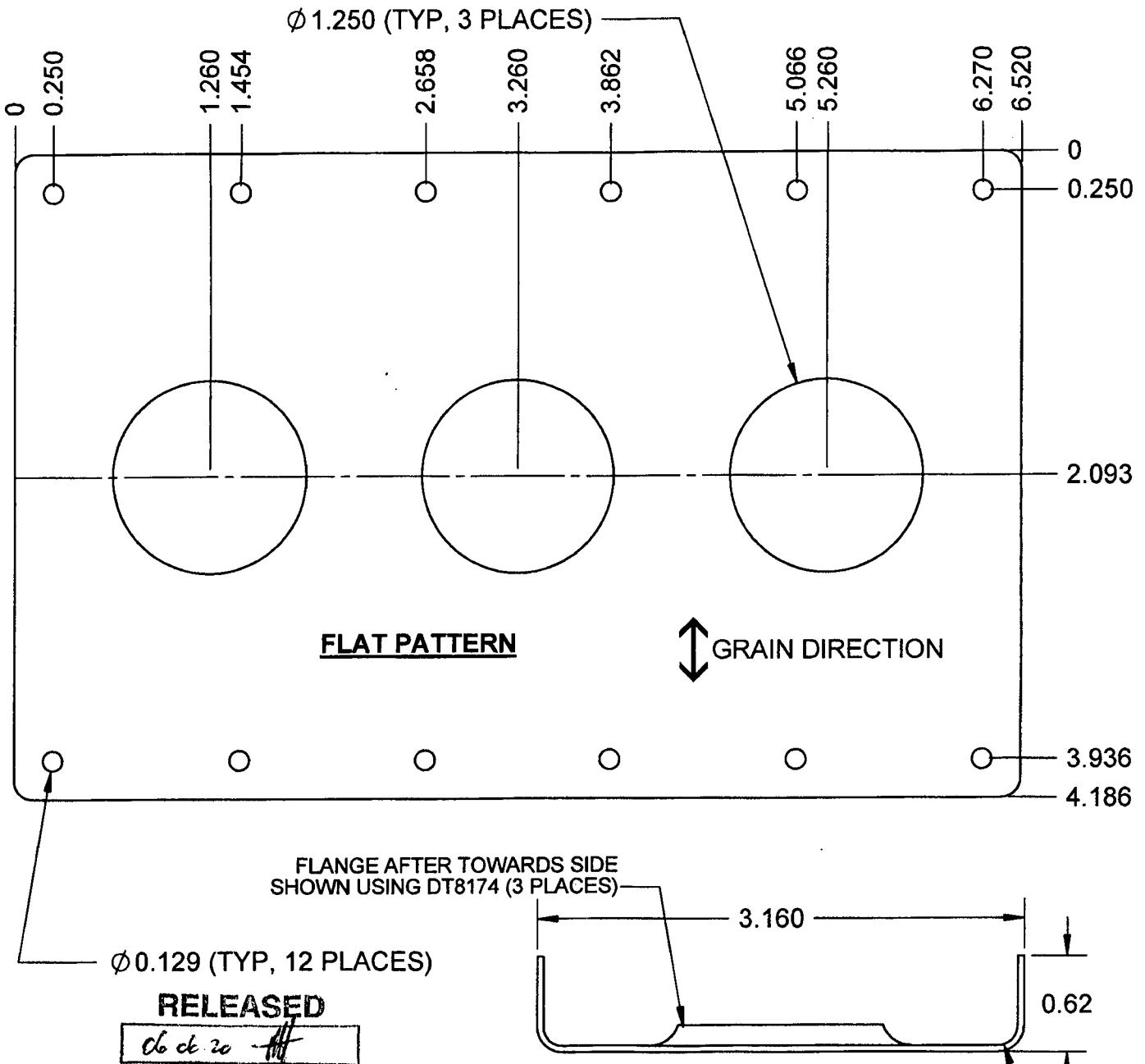
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# **DART**

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CHECKED <i>PH</i>	APPROVED <i>MM</i>	DRAWING NO. <b>D3065</b>	REV. B	SHEET 3 OF 5
DATE <b>06.05.23</b>	TITLE <b>STEP LEG ASSEMBLY</b>		SCALE	1:1



## **D3065-3 STEP SPACER**

1) MATERIAL: 2024-T3 (QQ-A-250/4)  
0.040 THICK (REF DART SPEC. M2024T3S.040) R

2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1

3) PART IS SYMMETRIC ABOUT CENTERLINE

4) BREAK ALL SHARP EDGES 0.005 TO 0.010

5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

6) ALL DIMENSIONS ARE IN INCHES

## BEND DETAIL

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**DART**

DESIGN	DRAWN BY	DART AEROSPACE LTD	
CHECKED	APPROVED	DRAWING NO.	REV. B
PH	<i>CH</i>	D3065	SHEET 5 OF 5
DATE	06.05.23	TITLE	SCALE
		STEP LEG ASSEMBLY	1:1

